

Work Order ID 64341

Friday, December 03, 2010 2:58:41 PM



Page 1

Item ID: D4106-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer, Sill Doulber

Start Date: 12/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-12-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4106

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Ky ndey

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

10-12-20

[Signature] 10/12/20 *[Stamp]*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-12-20

Work Order ID 64341

Friday, December 03, 2010 2:58:41 PM



Page 2

Item ID: D4106-5

Accept



Setup Start



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Stop



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Start Date: 12/2/2010 Start Qty: 6.00



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Required Date: 12/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/12/20



130

Identify as per dwg & Stock Location: 128

0.00



Packaging

Memo

0.00

Packaging

10/12/20 SD SD

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/21 JF
mf
10-12-21

Picklist Print

Page 1

Friday, December 03, 2010 2:58:45 PM

Work Order ID: 64341

Parent Item: D4106-5

Parent Item Name: Spacer, Sill Douber



Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-52068		Purchased	No			100	sf	393.5600	0.2109	1.332			



Kydex steel grey



1310-12-20

Location

Loc Qty

Loc Code

therm

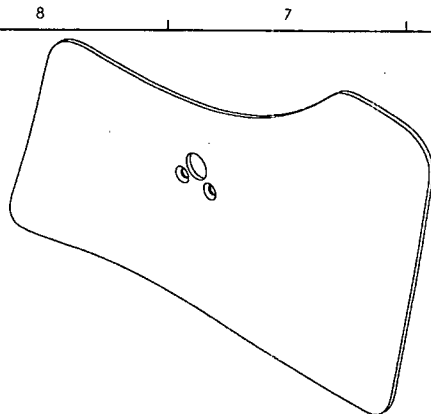
393.56

111807

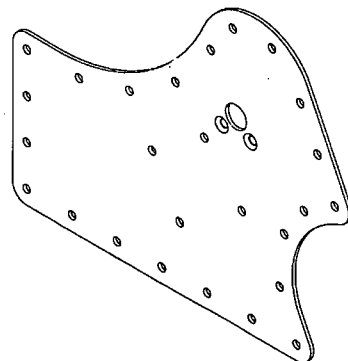
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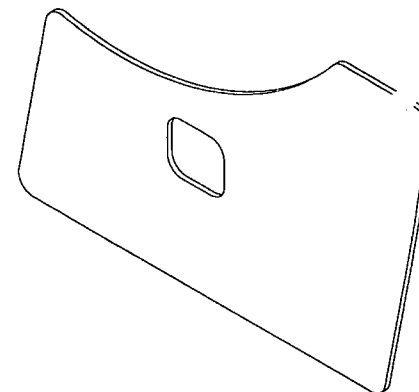




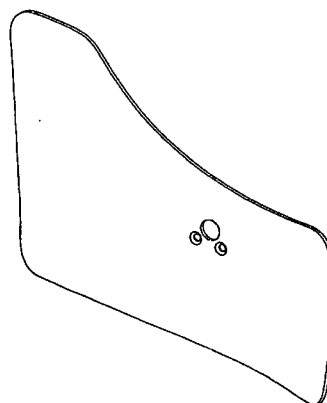
D4106-1 SILL DOUBLER, LH



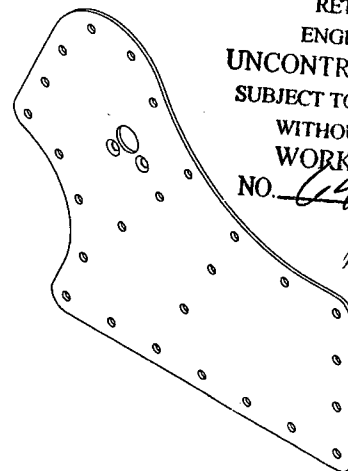
D4106-3 CREW DOOR DOUBLER, LH



D4106-5 SPACER, SILL DOUBLER



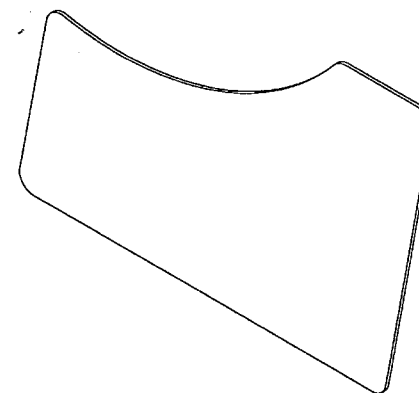
D4106-2 SILL DOUBLER, RH



D4106-4 CREW DOOR DOUBLER, RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *64344*

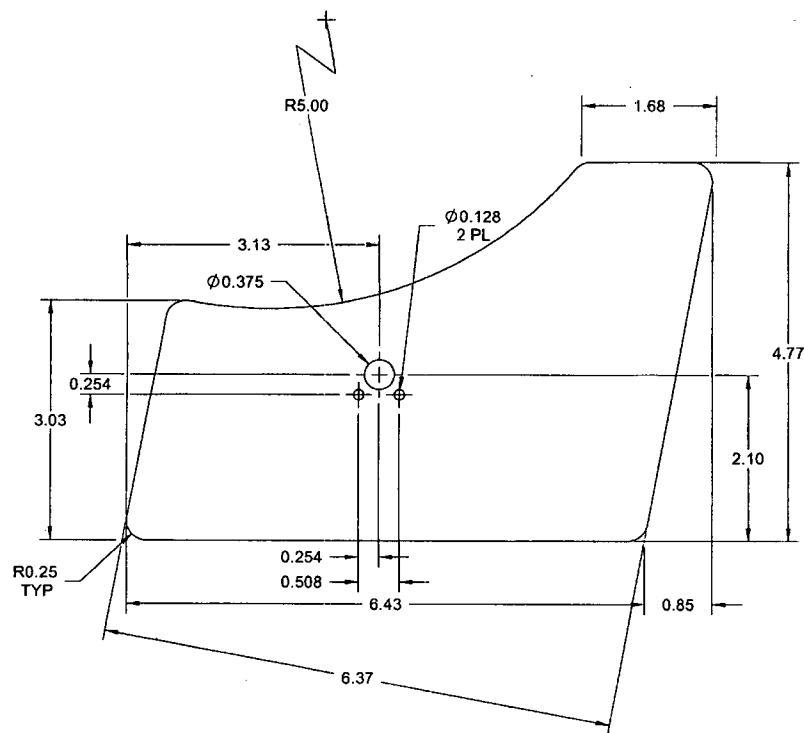
2/10-12-3



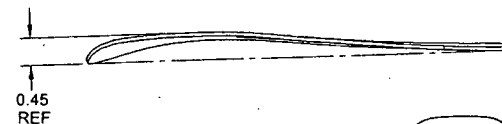
D4106-7 TEMPLATE

RELEASED
2010-09-23
AM

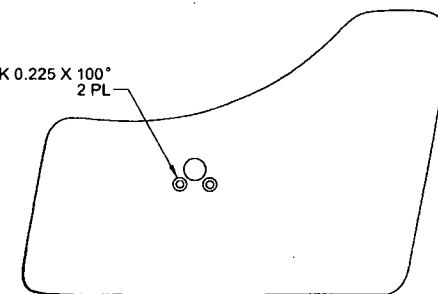
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DRAWN	JPH				
CHECKED	<i>[Signature]</i>	DRAWING NO. D4106		REV. A	
MFG. APPR.	<i>[Signature]</i>			SHEET 1 OF 5	
APPROVED	<i>[Signature]</i>	TITLE		SCALE	
DE APPR.	<i>[Signature]</i>	DOUBLERS		NTS	
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D4106-1F FLAT PATTERN, SILL DOUBLER



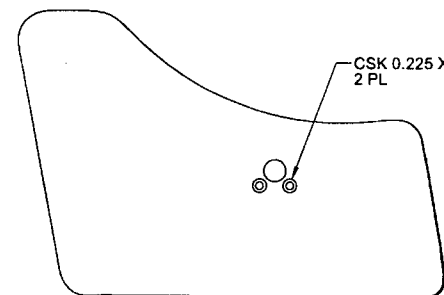
CSK 0.225 X 100°
2 PL



D4106-1 SILL DOUBLER, LH
(MAKE FROM D4106-1F)



CSK 0.225 X 100°
2 PL

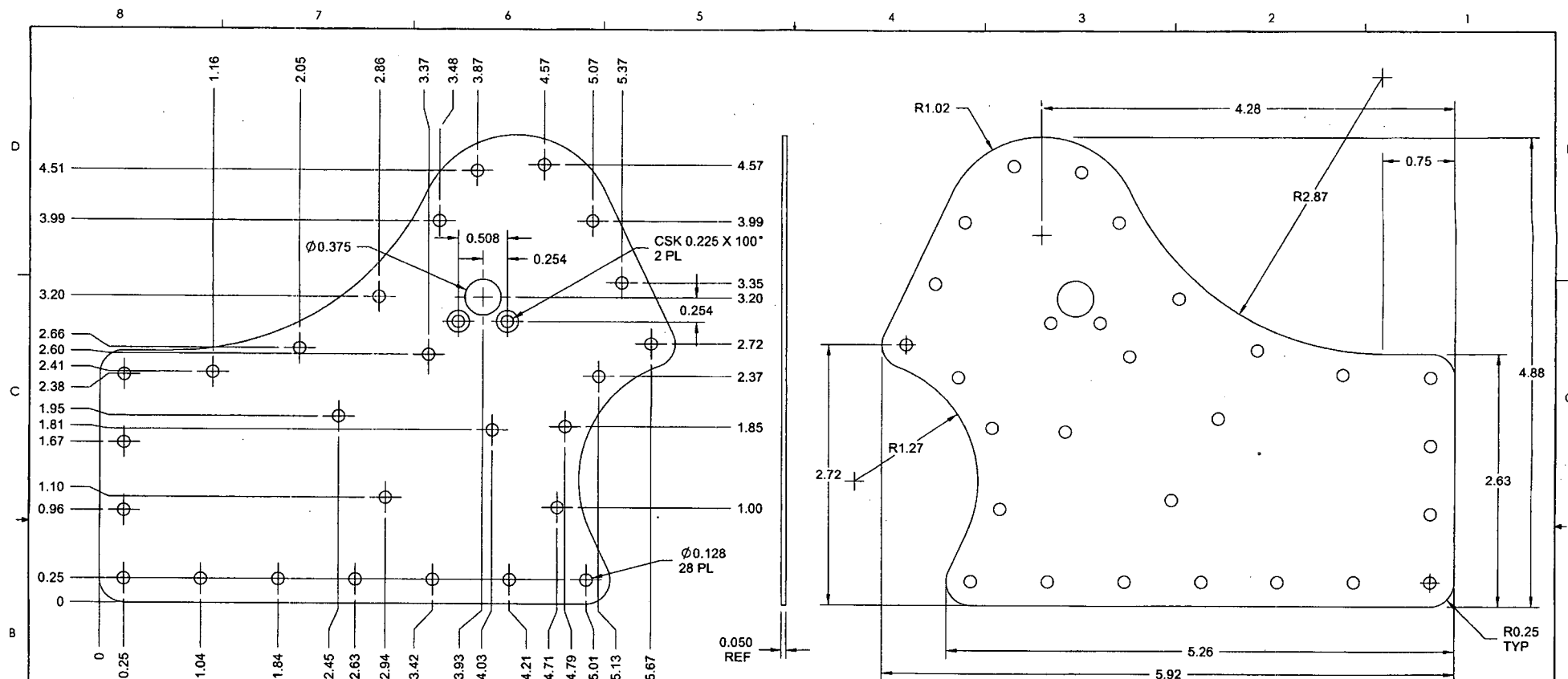


D4106-2 SILL DOUBLER, RH
(MAKE FROM D4106-1F)

RELEASE
2010-09-13

- NOTES:**
- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION -1 & -2: IDENT P/N D4106-X AND B/N PER QSI 044 6.1
 - 7) WEIGHT -1 & -2: 0.34 lbs
 - 8) FORM & INSPECT PER TEMPLATE DT9646 FOR D4106-1
DT9647 FOR D4106-2

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4106	SHEET 2 OF 5
APPROVED	JPH	TITLE	SCALE
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D4106-3 CREW DOOR DOUBLER, LH

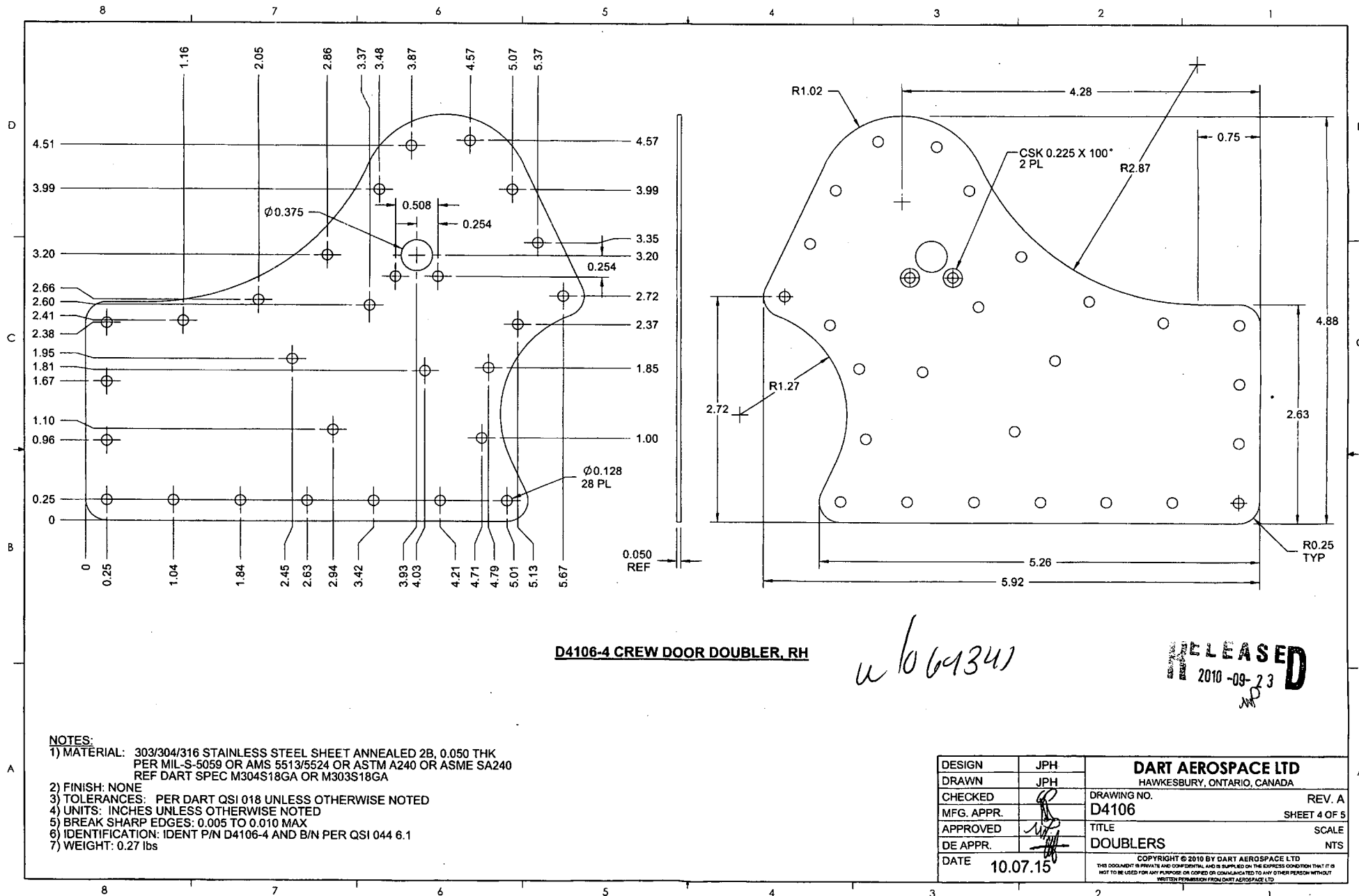
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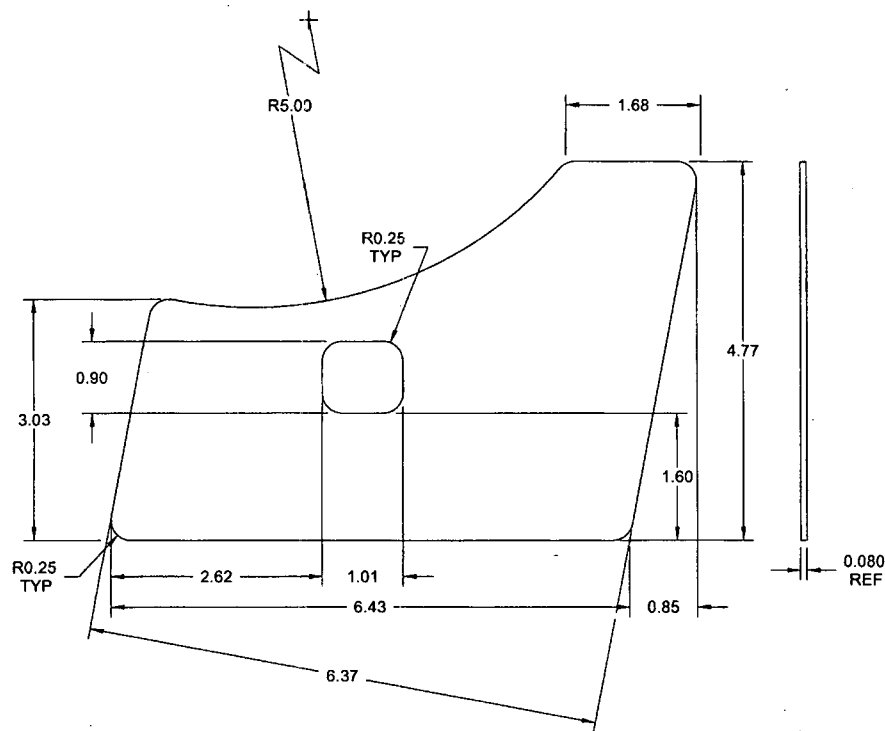
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-3 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

u 64341

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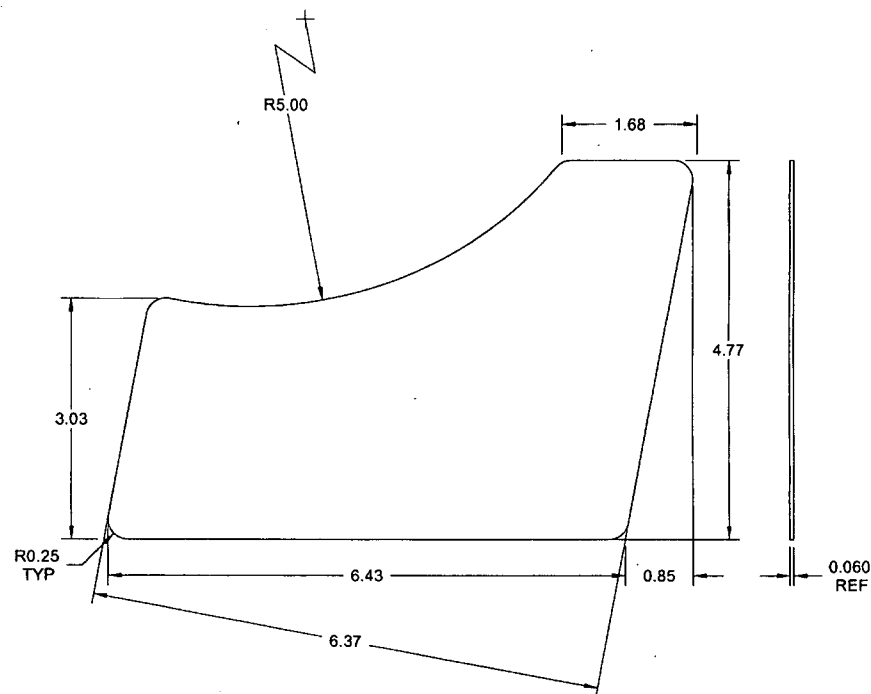




D4106-5 SPACER, SILL DOUBLER

NOTES:

- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015
- 7: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS.060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
- 7) WEIGHT -5: 0.08 lbs
-7: N/A



D4106-7 TEMPLATE

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2010-09-23
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